

Blue

Work Order ID: 55786



Page 1

February 1, 2010 10:24:10 AM

Item ID: D2891-1

Revision ID:

Item Name: 2.25 Support

Start Date: 2/02/10

Start Qty: 8.00 12.0

Required Date: 2/18/10

Req'd Qty: 8.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:   R  

Date: 10-2-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2891	Rev A1								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

B.A 10/02/04

12

0

HAAS CNC vertical machine #1

Machine as per Folio FA046 Tumble & Deburr

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

B.A 10/02/04

12

0

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

SA 10/02/05

12

0

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 55786

February 1, 2010 10:24:10 AM



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Item ID: D2891-1

Accept



Setup Start



Revision ID:

Stop



Item Name: 2.25 Support

Start Date: 2/02/10 Start Qty: 8.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 	SprayPaint	0.00							
	Spray Painting								
	Memo Prime grey per QS1005 110918 Paint Delfleet Blue B113171 Clear Delfleet B110899	0.00							
135 	QC14- Inspect Spray Paint	0.00							
	QC								
	Quality Control								
	Memo	0.00							
150 	Packaging								
	Packaging								
	Identify as per dwg & Stock Location: x-tube	0.00							
	Memo ASSY	0.00							

ml 10 05 17 (12)

ET 10 05 19

ml 10 05 19 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 55786**

February 1, 2010 10:24:10 AM



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Item ID: D2891-1

Accept



Setup Start



Revision ID:

Stop



Item Name: 2.25 Support

Start Date: 2/02/10 Start Qty: 8.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/05/19 *[Signature]*MF  
10-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February 1, 2010 10:24:14 AM

Page 1  
T

Work Order ID: 55786



Parent Item: D2891-1



Parent Item Name: 2.25 Support

Start Date: 2/02/10

Required Date: 2/18/10

Comments: IPP C 02.11.26 Added P/O KJ

Start Qty: 8.00

Required Qty: 8.00

IPP D 08.03.19 Re-format EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
DSK076		Manufactured	No			110	Each	17.0000	4.0000			



D2891-1 TURNING DETAIL

Warehouse                      Loc Qty                      Loc Code

Location

Main Warehouse

MAT

17

42244

1

43384

4

51184

5

52266

4

53400

3

\_\_\_\_\_  
3  
\_\_\_\_\_  
3  
\_\_\_\_\_

L.A 10/02/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	35784
<b>Description: Ø2.250 Support</b>		<b>Part Number:</b>	D2891-1
<b>Inspection Dwg: D2891</b>	<b>Rev: A1</b>	<b>Page 1 of 3</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AB	0.240	0.260		0.250	0.250	0.250	0.250	0.249
AC	0.115	0.150		0.125	0.125	0.125	0.125	0.125
AD	0.040	0.060		0.048	0.048	0.050	0.047	0.052
AE	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.310	0.310	0.310	0.310	0.310
AH	0.115	0.150		0.141	0.141	0.141	0.141	0.141
AI	0.454	0.474		0.470	0.468	0.459	0.461	0.460
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.042	1.042	1.040	1.040	1.041
AM	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AN	0.257	0.262		0.258	0.258	0.258	0.258	0.258
AO	1.663	1.683		1.677	1.677	1.669	1.672	1.670
AP	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AQ	0.022	0.042		0.030	0.030	0.030	0.030	0.030
AR								
AS								
AT								
Accept/Reject								

Measured by: H.A. Date: 10/02/04

Audited by: SA Date: 10/02/05

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 55786
<b>Description:</b> Ø2.250 Support		<b>Part Number:</b> D2891-1
<b>Inspection Dwg:</b> D2891	<b>Rev:</b> A1	<b>Page</b> 2 <b>of</b> 3

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	10
HAAS Section								
AA	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AB	0.240	0.260		0.249	0.250	0.250	0.249	0.249
AC	0.115	0.150		0.125	0.125	0.125	0.125	0.125
AD	0.040	0.060		0.051	0.050	0.049	0.050	0.050
AE	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.310	0.310	0.310	0.310	0.310
AH	0.115	0.150		0.141	0.141	0.141	0.141	0.141
AI	0.454	0.474		0.461	0.467	0.468	0.467	0.465
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.047	1.047	1.047	1.040	1.040
AM	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AN	0.257	0.262		0.258	0.258	0.258	0.258	0.258
AO	1.663	1.683		1.673	1.677	1.677	1.677	1.675
AP	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AQ	0.022	0.042		0.030	0.030	0.030	0.030	0.030
AR								
AS								
AT								
Accept/Reject								

<b>Measured by:</b> H.A	<b>Date:</b> 10/02/04
<b>Audited by:</b> S.A	<b>Date:</b> 10/02/06
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	55784
<b>Description:</b> Ø2.250 Support		<b>Part Number:</b>	D2891-1
<b>Inspection Dwg:</b> D2891	<b>Rev:</b> A1	<b>Page</b> 3 <b>of</b> 3	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

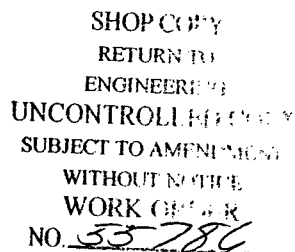
☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	0.188	0.193		0.188	0.188			
AB	0.240	0.260		0.249	0.249			
AC	0.115	0.150		0.125	0.125			
AD	0.040	0.060		0.051	0.050			
AE	0.010	0.020		0.015	0.015			
AF	0.240	0.260		0.250	0.250			
AG	0.290	0.310		0.310	0.310			
AH	0.115	0.150		0.141	0.141			
AI	0.454	0.474		0.467	0.466			
AJ	2.779	2.789		2.784	2.784			
AK	0.240	0.260		0.250	0.250			
AL	1.002	1.042		1.037	1.039			
AM	0.053	0.073		0.063	0.063			
AN	0.257	0.262		0.258	0.258			
AO	1.663	1.683		1.677	1.675			
AP	0.053	0.073		0.063	0.063			
AQ	0.022	0.042		0.030	0.030			
AR								
AS								
AT								
Accept/Reject								



<b>Measured by:</b> H. A	<b>Date:</b> 10/02/05
<b>Audited by:</b> [Signature]	<b>Date:</b> 10/02/05
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	[Signature]

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ ) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



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AI	#CP 02/01/23	UPDATE DIMS AS MANUFACTURED	
A	00.11.17	NEW ISSUE	
DESIGN	DRAWN BY		<b>DART AEROSPACE LTD.</b> MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED		
DATE		TITLE	SCALE
00.11.17		Ø2.250 SUPPORT	1:1